

Work Order ID 69596

Thursday, May 12, 2011 3:24:18 PM



Page 1

Item ID: D3171-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3171

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3171

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

304 .063

1B11-5-17

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B11-5-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/05/12

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Debur if necessary

N/A

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Bend as per Dwg D3171 Tumble

SB 11/05/18

(14)

11-5-19

(14)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 11/05/19

(14)

W/O:		WORK ORDER CHANGES					
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Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 38

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/19 sf (14)x

11/5/19 sf

11-05-19
(14)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:24:25 PM

Page 1

Work Order ID: 69596

Parent Item: D3171-1

Parent Item Name: Angle



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 02.11.04 New Issue KJ
IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

201.4000

0.0206

0.173474



B 11-5-17

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

201.4

117275

41.4

117653

160

117275

14

W/O:		WORK ORDER CHANGES					
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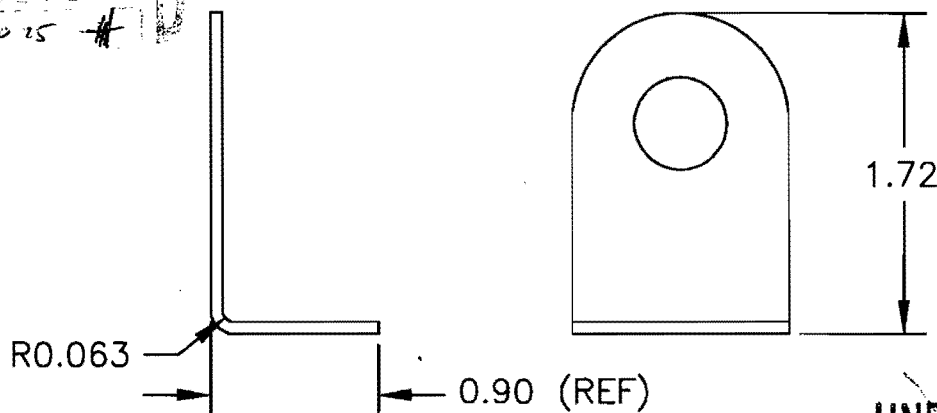
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.08 *[Signature]*



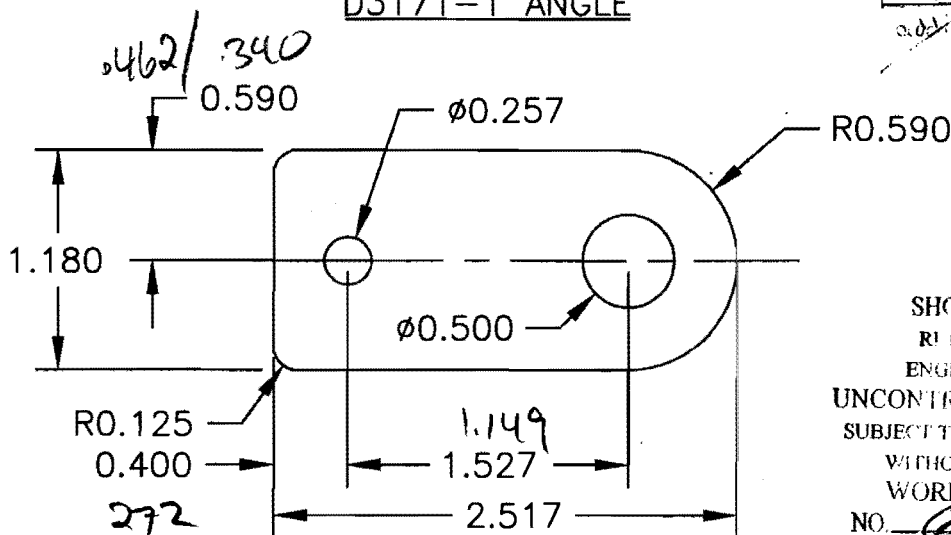
D3171-1 ANGLE

~~UNDER REVIEW~~

~~07.04.02 CB~~

~~adding -3~~

OK
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69596

11-05-03

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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